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D3255-041

Job Sheet 191520



Part No: D3255-041

Job Qty: 4 pcs

Part Name: Access Panel Assembly LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	3/29/19		0.00	12.50	Large Fab - 1		102
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 10	4 pcs	3/29/19		0.00	0.00	QC 10 - 10		2
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
120	QC 5	4 pcs	3/29/19		0.00	0.00	QC 5 - 10		DAS 100-0-0-0000-0 9-00
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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130 Powdercoat - 3 Grey Sand - B4B	4 pcs	3/29/19	0.00 0.32	QC 5 - 9	
				QC 5 - 50	CL
				QC 5 - 30	
				Powdercoat - 1 - B4B	
140 QC 3	4 pcs	3/29/19	0.00 0.00	Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	DR 19-04-1
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	DAS 58 APR 02 2019
				QC 3 - 59	9-89
				QC 3 - 6	
150 Small Fab - 2 - B4B	4 pcs	3/29/19	0.00 4.44	QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				Small Fab - 1 - B4B	DAS 58 APR 02 2019
				Small Fab - 2 - B4B	9-89
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
160 QC 5	4 pcs	3/29/19	0.00 0.00	Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS 68 APR 03 2019
				QC 5 - 68	9-89
170 Packaging 3-1 - Stock - B4B	4 pcs	3/29/19	0.00 0.00	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	APR 04 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
180 QC 21 - SA	4 pcs	3/29/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-85 APR 04 2019
Part Op 100 - 1-Weld as per Dwg D3255 ***purge weld*** A/R SS ROD Batch: <u>10585</u> 2-Grind Welds Flush Descriptions: 110 - (QC10- Inspect visual per QSI004- ground welds) 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____ 140 - (QC3- Inspect Part Finish) 150 - (Small Fab) 1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg D3255 A/R 736 DOW CORNING ADHESIVE Batch: _____ 160 - (QC5- Inspect part completeness to step on W/O)					

170 - (Identify as per dwg & Stock Location: _____)
180 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3255-1	Panel	4 Ea (1 ea)	100-Large Fab - Welded Assy-1	5/22071
D3255-3	Cap	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5106876
D3255-5	Gasket	4 pcs (1 ea)	150-Small Fab - 2 - B4B	5006019

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D3255-1	4	4	0
	D3255-3	4	9	0
150-Small Fab - 2 - B4B	D3255-5	4	8	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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Container No: S167308



Part: D3255-041

Job No: 191520

Serial No/Batch: S167308

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/28/19